



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4635-4

Job Sheet 168883



167060

Part No: D4635-4

Job Qty: 11 ea

10

Part Name: Aft Ceiling Panel, RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/23/17

Job Tracking No:

Due Date: 11/10/17

Created By: Sonia Plouffe

Type: SOLD

Description:

Note: DWG REV F SHEETS 16,17,18 IPP Rev. A New Issue 12/05/07 DL VERIFIED BY:JLM IPP Rev. B Dwg.
Update 12/11/08 DL IPP Rev C Dwg. Update 13/07/09 DL IPP Rev. D Dwg, Update, Material Change 13/12/18
DL IPP Rev. E Dwg. Update 14/01/09 DL IPP Rev F Dwg, Update 15/01/27 DL

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Purchasing	11 pcs		11/10/17	0.00	0.00	Purchasing		13-12-17
140	Packaging	11 pcs		11/10/17	0.00	0.00	Packaging2		13-12-17
150	QC	11 pcs		11/10/17	0.00	0.00	QC6		17/12/14
170	Packaging	11 pcs		11/10/17	0.00	0.00	Packaging3		
180	QC21-SA	11 Ea		11/10/17	0.00	0.00	QC21		

Part Op 140 - Receive & Inspect for Damage & Mat'l Certs
Descriptions: 150 - QC6- All purchased or subcontracted products
170 - Identify as per dwg & Stock Location: _____
180 - QC21- Final Inspection - Work Order Release

DEC 14 2017

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
110-Purchasing	D4635-4P	11	1	0	0
	MLEXS.093-F6006-07	103	1,879	0	0

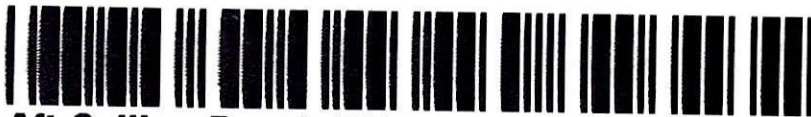
Part Specifications

Specifications could not be found.

DART
AEROSPACE
S021577

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Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Aft Ceiling Panel, RH

PART NO: D4635-4

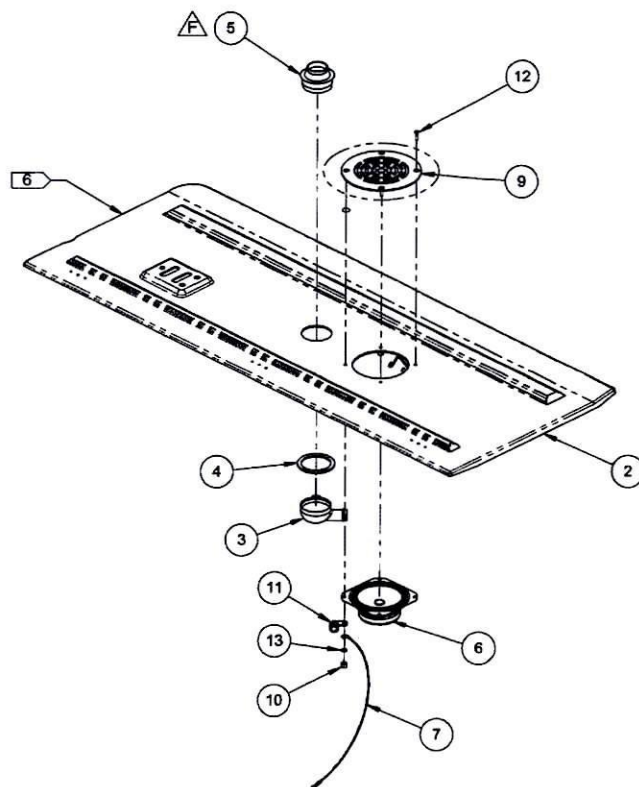
Revision:

Operation: Purchasing

Change No:

Mfg Date: 12/13/17

Job No: 168883



D4635-044 RH, AFT CEILING PANEL ASSY

ITEM	QTY -044	P/N	DESCRIPTION
1	X	D4635-044	RH, AFT CEILING PANEL ASSY
2	1	D4635-144	RH, AFT CEILING REPLACEMENT PANEL ASSY
3	1	D4646-1	PLENUM CAP ASSEMBLY
4	1	D4652-3 (REF)	MOUNTING NUT (PART OF D4652-5)
5	1	D4652-5	AIR VALVE, 1.16 ID DISK TYPE
6	1	D4655-1	SPEAKER
7	1	D4708-9	LANYARD
8	1	D4728-046	RH SPEAKER #3 HARNESS ASSY
9	1	D4743-1	SPEAKER GRILL
10	4	MS21044-N08	NUT, SELF-LOCKING
11	3	MS21919WDG8	CLAMP
12	4	MS24693-BB51	SCREW, CSK 100°
13	4	NAS1149DN832J	WASHER

NOTES:

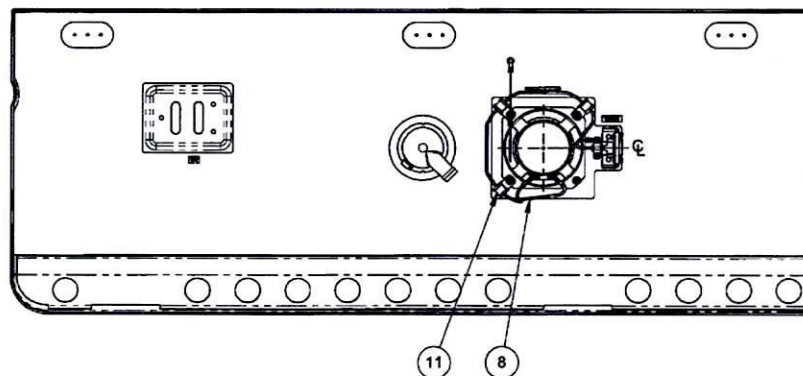
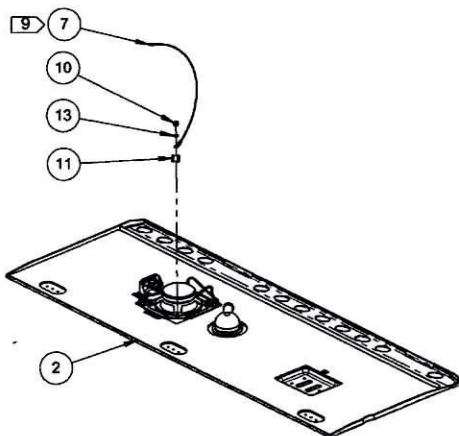
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4, ON SMOOTH SIDE
- 7) WEIGHT: 5.0 lbs
- 8) INSTALL D4728-046 WIRE HARNESS PER QSI 048
- 9) ON D4708-9 LANYARD OPEN TO $\varnothing 0.196$ BOTH ENDS

RELEASED

2015 JAN 26 *up*

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DRAWN	RF		
CHECKED	AK	DRAWING NO.	REV. F
MFG. APPR.	DL	D4635	SHEET 7 OF 18
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	OUTBOARD CEILING PANELS	NTS
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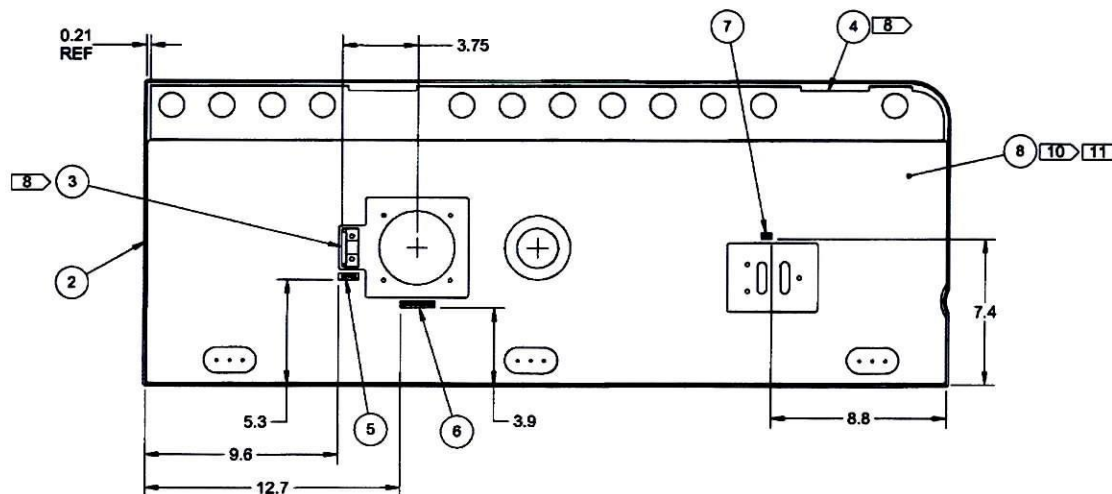
D4635-044 RH. AFT CEILING PANEL ASSY
AUXILIARY VIEW

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ITEM	QTY -144	P/N	DESCRIPTION
1	X	D4635-144	RH, AFT CEILING REPLACEMENT PANEL ASSY
2	1	D4635-4	RH, AFT CEILING PANEL
3	1	D4669-1	BRACKET
4	1	D4695-4	CHANNEL
5	1	D4732-11	LABEL
6	1	D4732-39	LABEL
7	1	D4732-41	LABEL
8	1	D5022-5	FOAM, SIDE PANEL, AFT, RH



D4635-144 RH, AFT CEILING REPLACEMENT PANEL ASSY

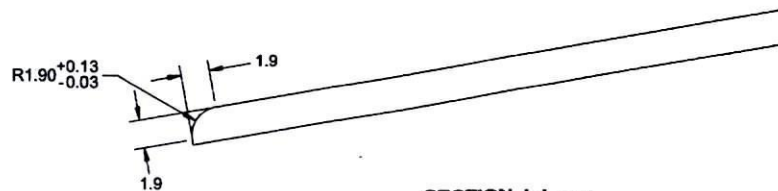
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) APPLY A BEAD (0.20 TO 0.30 WIDE) OF DEVCON PLASTIC WELDER II (0.25 INSIDE OF BOTH EDGES OF PART) TO BOND D4669-1, D4695-4. WAIT FOR 2 TO 4 HOURS FOR FUNCTIONAL CURE
- 9) LOCATE LABELS AS SHOWN, SEAL LABELS USING 3950 EDGE SEALER OVER LABEL TOP SURFACE
- 10) APPLY AN EVEN COAT OF 3M SCOTCH WELD 1300L CONTACT ADHESIVE TO BOND D5022-5 FOAM CORE TO INSIDE OF PANEL
- 11) CENTER D5022-5 FOAM ON D4635-4

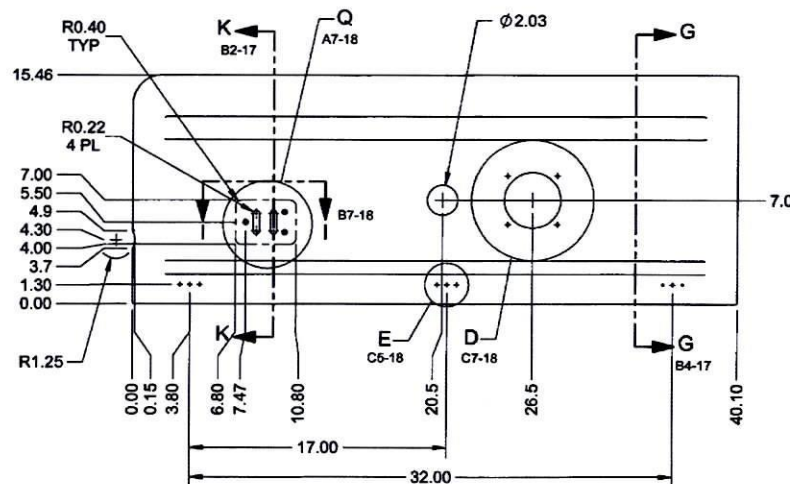
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SECTION J-J C2-16



D4635-4 RH, AFT CEILING PANEL

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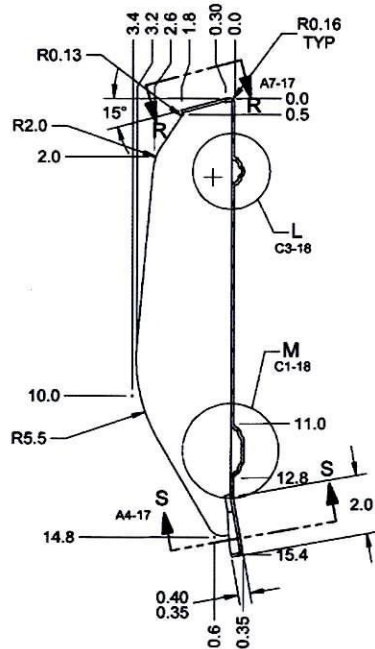
- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS.093-F6006-07)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.66 lbs
- 8) TEXTURE ON THIS SIDE
- 9) TRIM D4635-4 PER TOOL DT9842
- 10) THERMOFORM D4635-4 PER QSI 022 USING DT9850 TOOL
MIN. THICKNESS AFTER FORMING:
RIDGES/EDGES = 0.060
ELSEWHERE = 0.070

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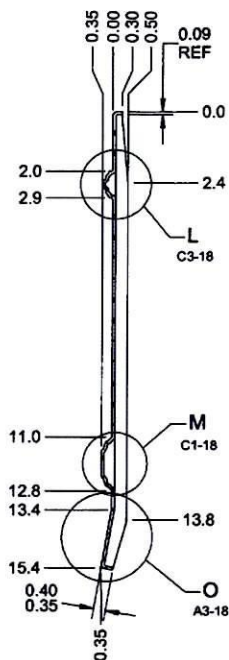
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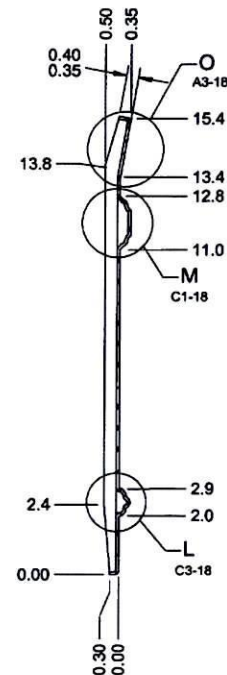
SECTION A-A
SECTION A-A' OPPOSITE
SCALE 2X

B3-13
B3-14



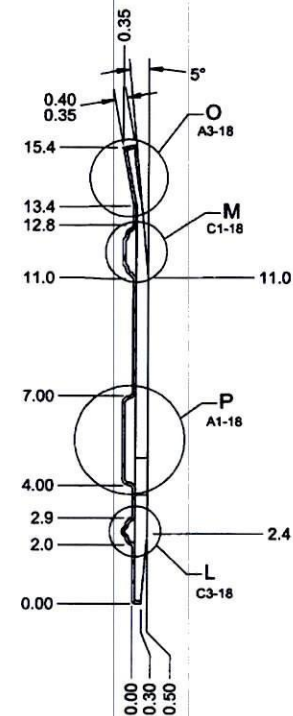
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SCALE 2X

B7-13
B7-14



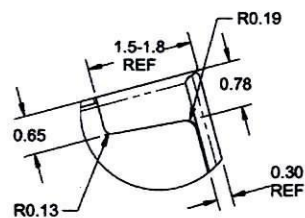
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SCALE 2X

B4-15
B4-16



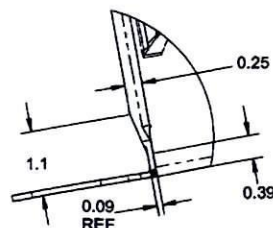
SECTION K-K
SCALE 2X

C6-16



AUXILIARY VIEW R-R
SECTION R-R' OPPOSITE
SCALE 2X

D7-17



AUXILIARY VIEW S-S
SECTION S-S' OPPOSITE
SCALE 2X

B7-17

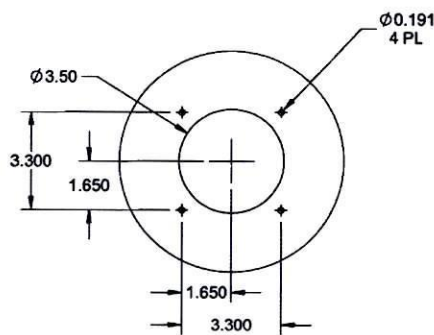
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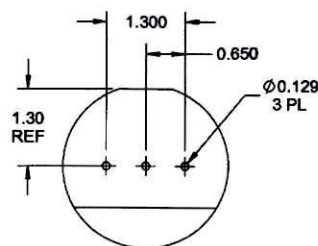
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DRAWING NO. D4635	REV. F
TITLE OUTBOARD CEILING PANELS	SCALE NTS
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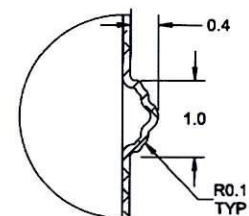
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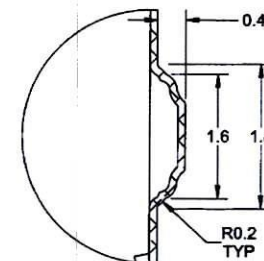
DETAIL D
SCALE 2X
B4-13
B3-14
B5-15
B5-16



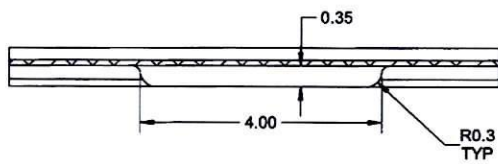
DETAIL E
SCALE 4X
C7-13
B6-14
C6-15
B5-16



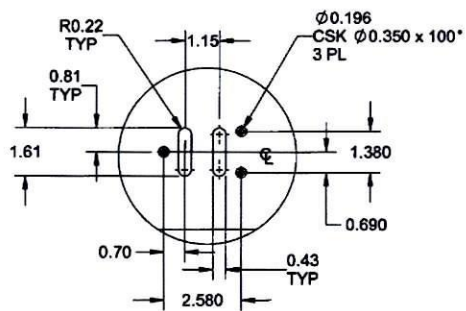
DETAIL I
SCALE 1.5X
B2-17
B4-17
C5-17
C7-17



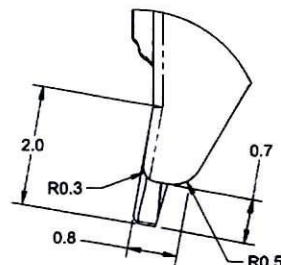
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SCALE 1.5X
C2-17
C3-17
C5-17
C7-17



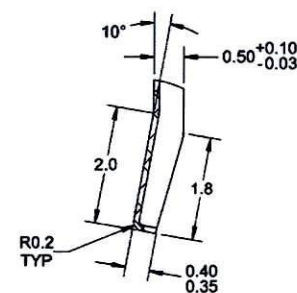
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B5-16



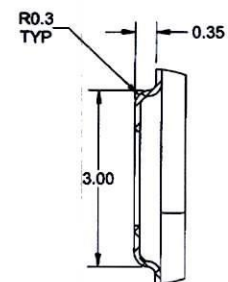
DETAIL Q
SCALE 2X
C5-16



DETAIL N
SCALE 2X
B2-13



DETAIL O
SCALE 2X
D2-17
D3-17
B5-17



DETAIL P
SCALE 4X
C2-17

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2015 JAN 26

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8 7 6 5 4 3 2 1

D

C

B

A

D

C

B

A

Certificate Of Conformance



Customer: DART AEROSPACE LTD

P.O. # 38131

SO # 020787

Part #	<u>D4635-4</u>	Qty.	<u>10</u>	Batch #	<u>004</u>
Description	<u>AFT CEILING PANEL, RH</u>	Material usage	<u>4 SHTS</u>	Lot#	<u>0006902432</u>
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	

Note: All parts are not identified as meeting QSI044.

By: AS

(Approved QA Signatory)

Date: DEC. 12, 2017

C O F C # 021

Page: 1 of 1

Plas-Tech Inc. 115 Applewood Cres. Concord, Ontario L4K 5C1 Tel: (416) 736-0004 Fax: (416) 736-0010

Email: info@plasteconline.com, Web: www.plasteconline.com

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17/12/17